

Work Order ID 77497

December-09-11 7:07:05 AM

77497

Page 1

Item ID: D412-711-101

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Replacement Bubble Window

Start Date: 12/09/11 Start Qty: 4.00

4

Cust Item ID:

Required Date: 12/16/11 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D412-711-101

A

100

0.00

100

DC

Document Control

Memo

Photocopy bluefiles and create labels
for PPP D412-711-101 Change 002

0.00

5/12/13

*John MLS 11-12-13
(4)*

110

0.00

110

HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

Set up Machine as per folio FTA 077 and D711W program using mould DT9640

0.00

*Wh.
11/12/09*

120

0.00

120

HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

Cut Blanks to 37.5" by 43"

0.00

*Wh.
4/12/09*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

130

0.00

130

THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

Thermoform as per Dwg. D412-711-101 using DT 9640 and Folio FTA
077 Dwg. Rev. A Folio Rev.A

(4)

B 11/12/09

140

0.00

140

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1) Check Surface finish for undesired marks, voids, dimples etc.2) Check
depth of bubble to ensure conformity to drawing tolerances.Yh.
11/12/09

150

0.00

150

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

(4)

B 11/12/09

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Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

160

HandThermo

Hand Finishing Thermoforming

HAND FINISHING THERMOFORMING

Memo

0.00

1) Trim off excess flange material
blemishes2) Buff out any light scratches or
3) Etch part number and batch number

x 4

11/12/12

170

170

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

1) Visually inspect for clarity, and proper formation.

x 4

11/12/13

180

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

1) Visually inspect for clarity, and proper formation.

8 u 42/13

(40)

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QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

185

QC4- 100% Inspect kits for completeness

0.00

185

QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location: 091

0.00

190

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00

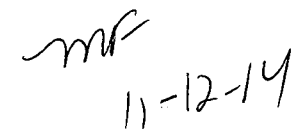
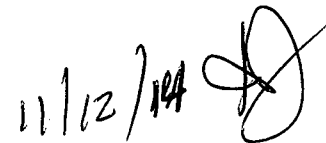
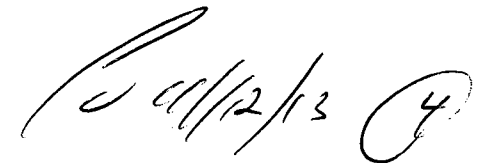
200

QC

Memo

0.00

Quality Control



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Picklist Print

December-09-11 7:07:05 AM

Page 1

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Parent Item: D412-711-101

Parent Item Name: Replacement Bubble Window

Start Date: 12/09/11

Required Date: 12/16/11

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-02-01 JLM
10/06/28 DL

IPP Rev. B. Manufacture in-house

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.236 Plexiglass G .236"		Purchased	No				sf	352.6667		85.333333			

Location

therm

116030

117563

119347

Loc Qty

352.66667

37.33333

8.33334

307

Loc Code

85.33337 sf. ,

DL
11/17/12

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DART AEROSPACE LTD		Work Order: 77497
Description: Replacement Window		Part Number: D412-711-101
Inspection Dwg: D412-711-101	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>N/A</u> "				
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: <u>DL</u>	Date: <u>11/12/09</u>
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.00	+/-0.030	<u>2.026"</u>			<u>Vern DL-02</u>	
1.73	+/-0.030	<u>1.76"</u>			<u>Vern DL-02</u>	
1.98	+/-0.030	<u>1.986"</u>			<u>Vern DL-02</u>	
1.50	Min	<u>1.53"</u>			<u>Vern DL-02</u>	
0.090	Min	<u>0.093</u>			<u>ULTRA</u>	
0.070	Min	<u>0.084</u>			<u>ULTRA</u>	
0.050	Min	<u>0.070</u>			<u>ULTRA</u>	
15.0	+/-0.5	<u>15.0"</u>			<u>TAPE DL-01</u>	

Measured by: <u>DL</u>	Date: <u>11/12/12</u>
Audited by: <u>S</u>	Date: <u>11/12/12</u>
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.10.08	New Issue	KJ	<u>[Signature]</u>

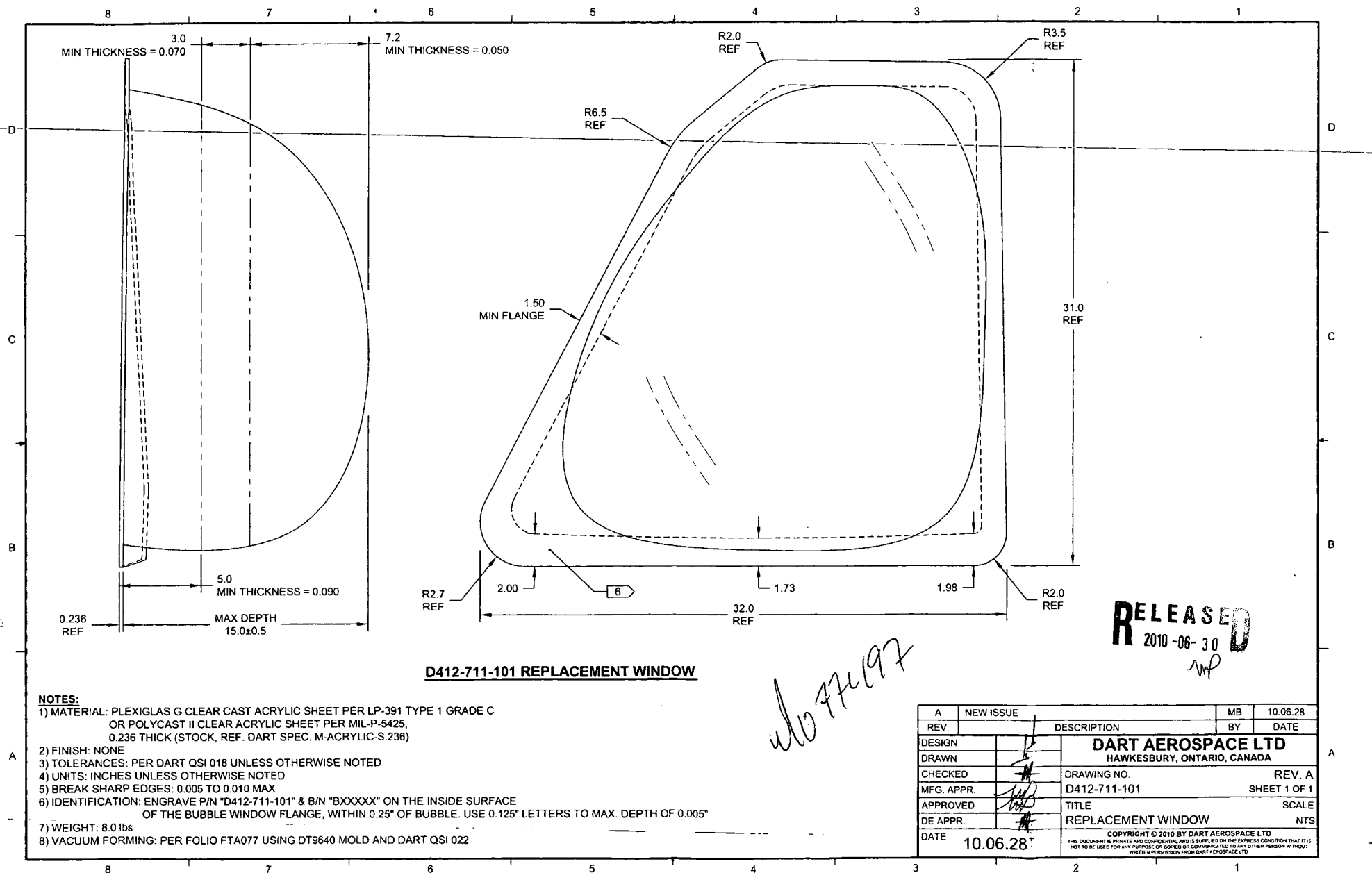
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